



Dart Hawkesbury
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D4894-3
Job Sheet 168174



Part No: D4894-3 Job Qty: 3 ea
Part Name: Aft Beam
Part Weight: 0 lbs Status: Scheduled Priority: Medium
Job Created: 11/10/17 Job Tracking No:
Due Date: 12/27/17 Created By: Mario Poulin
Type: **SOLD** Description:
Customer: Pacific Helicopters Pty - Asia Pacific (CPACI02)
PO Box 342, Goroka, Eph Papua, , 441 Papua New Guinea ph:011 675 732 1833 fx:011 (675) 5321503.
Note: DWG REV B SHEET 2 IPP REV:B 13.05.27 AS PER DWG REV.A DD VERF:JLM
Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	3 Ea		12/26/17	0.00	0.00	Start Up Waterjet1		17/12/02
100	Waterjet	3 pcs		12/26/17	0.00	8.15	Waterjet1		17/12/02
110	QC	3 pcs		12/26/17	0.00	0.00	QC2		17/12/02
114	Mill Conv	3 pcs		12/26/17	0.00	3.85	Mill Conv 1		S.C.L. 17-12-07
116	QC	3 pcs		12/26/17	0.00	0.00	QC2		S.C.L. 17-12-07
120	QC	3 pcs		12/26/17	0.00	0.00	QC8		H.A 17-12-12
130	HandFinish	3 pcs		12/26/17	0.00	0.76	HandFinish1		2017-12-12 JSC
140	QC	3 pcs		12/26/17	0.00	0.00	QC7		DK 17-12-12
141	Powdercoat	3 pcs		12/27/17	0.00	0.50	Powdercoat1		BR 17-12-12
142	QC	3 pcs		12/27/17	0.00	0.00	QC3		38 DAC
145	QC	3 pcs		12/27/17	0.00	0.00	QC5		9-89 38
150	Packaging	3 pcs		12/27/17	0.00	0.00	Packaging3		SMP 9-89
160	QC21-SA	3 Ea		12/27/17	0.00	0.00	QC21		21 DEC 1 2017

Part Op 100 - 1-Cut as per Dwg Dwg Rev: B Prog Rev: B 2-Deburr if necessary
Descriptions: 110 - QC2- Inspect parts off machine FAI/FAIB
114 - DRILL HOLES AS PER DWG
116 - QC2- Inspect parts off machine FAI/FAIB
120 - QC8- Inspect parts - second check
130 - Chemical Conversion Coat per QSI005 4.1
140 - QC7-Inspect Chemical Conversion Coat
141 - White Gloss(Ref.4.3.5.1) per QSI005 4.3-Alum MASK AS PER NOTE 8 START TIME: 2:30 OVEN
TEMPERATURE: 320° FINISH TIME: 3:00 OFF 3:00 M138467
142 - QC3- Inspect Part Finish
145 - QC5- Inspect part completeness to step on W/O
150 - Identify as per dwg & Stock Location:
160 - QC21- Final Inspection - Work Order Release

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	M6061T6B1.000X06.000	14	60	0	0

138037
138109

10.5

Part Specifications

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / DATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	Skid-tu Machir Thermoform Large QT	CONTENT/PROCESS Engineering ☐ Quality ☐ Approval ☐ Deleted By _____ and / Supervisor Approval Verification _____ QC / QA Coordinator Approval _____																																																				
Date : _____ Step #: _____		D4894 - 3 Start up Operation Mfg Date: 12/04/17 Job No: 168174 PART NO: Revision: Operation: Change No:																																																					
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DART AEROSPACE LTD		Work Order:	168174
Description: Aft Beam		Part Number:	D4894-3
Inspection Dwg: D4894	Rev: B	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
55.02	+/-0.030	55.02	1		V. 02-02	
19.63	+/-0.030	19.63	1		Top	
7.38	+/-0.030	7.38	1			
10.61	+/-0.030	10.61	1			
5.25	+/-0.030	5.25	1			
8.25	+/-0.030	8.25	1			
1.50	+/-0.030	1.505	1			
3.50	+/-0.030	3.494	1			
0.65	+/-0.030	0.624	1			
9.56	+/-0.030	9.56	1			
4.65	+/-0.030	4.65	1			
28.80	+/-0.030	28.80	1			
7.16	+/-0.030	7.16	1			
4.47	+/-0.030	4.47	1			
1.00	+/-0.030	1.00	1			
3.50	+/-0.030	3.508	1			
0.75	+/-0.030	0.740	✓			
1.800 Pitch	+/-0.005	1.800	✓			
3.600	+/-0.005	3.600	✓			
0.60	+/-0.030	0.600	✓			
2.300	+/-0.005	2.300	✓			
Ø0.377	+0.006/-0.001	0.379	✓			
2.00	+/-0.030	2.006	✓			
0.60	+/-0.030	0.597	✓			
Ø0.129	+0.005/-0.001	0.129	✓			

Measured by:	2/5.0.0.0	Audited by:	L.F.	Preliminary Approval:	
Date:	17/12/02/17-02-07	Date:	17-12-12	Date:	
Rev	Date	Change	Revised by	Approved	
A	14.11.13	New Issue	KJ		